

Work Order ID 126996

126996

Page 1

Friday, January 23, 2015 1:17:30 PM

Item ID: D412-760-111

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Cabin Wall & Pylon Protector

Stop

NS2

Start Date: 12/16/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/19/2014 Req'd Qty: 5.00

5

Customer:

**REPRINT
TO QC 21**

Reference:

Run Start

NR1

Approvals: Process Plan: umf

Date: 15-1-23

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
IIN D412-760	G

100 Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-760-111 CHG002

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
66
3-39

JAN 23 2015

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

For 100% w/o

5/15/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Work Order ID 126996***126996***

Page 2

Friday, January 23, 2015 1:17:30 PM

Item ID: D412-760-111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 12/16/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/19/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-760-011

Location: _____

PPP Rev: _____

DAS
06
8-69

JAN 23 2015

140

QC21 - Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

S. Stalder

Could not
find
original
work
order
MF 15-1-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 23, 2015 1:17:33 PM

Work Order ID: 126996

126996

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 12/16/2014

Required Date: 12/19/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3933-1 *D3933-1* Aft Wall Protector		Manufactured	No			110	Each	0.0000	DAS PS 9-09 **	5 <u>126980 MF 15-1-23</u>			
D3933-2 *D3933-2* Aft Wall Protector, RH		Manufactured	No			110	Each	0.0000	1 DAS PS 9-09 **	5 <u>126999 MF 15-1-23</u>			
D3935-1 *D3935-1* Pylon Wall Protector, LH		Manufactured	No			110	Each	1.0000	1 DAS PS 9-09 **	5 <u>126981 MF 15-1-23</u>			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST500				1					
				127293				1					
D3935-2 *D3935-2* Pylon Wall		Manufactured	No			110	Each	1.0000	1 DAS PS 9-09 **	5 <u>126992 MF 15-1-23</u>			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST500				1		<u>127009.</u>			
				127294				1					
D3942-1 *D3942-1* Angle		Manufactured	No			110	Each	90.0000	14.15 DAS PS 9-09 **	70 <u>127009 MF 15-1-23</u>			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST068				90					
				127009				90					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 23, 2015 1:17:33 PM

Page 2

Work Order ID: 126996

126996

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 12/16/2014

Required Date: 12/19/2014

Start Qty: 5.00

Required Qty: 5.00

D3942-3 Manufactured No

110 Each 66.0000 10 50

D3942-3

Clip

** PAS
CS
3-09

Location

Loc Qty

Loc Code

ST068

66

126977

22

128366

44

MF 15-1-23

MS27039-4-10 Purchased No

110 Each 16.0000 4 20

MS27039-4-10

Screw

** PAS
CS
3-09

Location

Loc Qty

Loc Code

ST283

16

124552

16

MF 15-1-23

MS27039-4-14 Purchased No

110 Each 118.0000 6 30

MS27039-4-14

SCREW

** PAS
CS
3-09

Location

Loc Qty

Loc Code

CA

13

m129682

13

ST283

105

m131049

5

m131197

100

MF 15-1-23

MS27039-5-08 Purchased No

110 Each 30.0000 6 30

MS27039-5-08

Screw

** PAS
CS
3-09

Location

Loc Qty

Loc Code

ST282

30

m131074

30

MF 15-1-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Picklist Print

Page 3

Friday, January 23, 2015 1:17:33 PM

Work Order ID: 126996

126996

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 12/16/2014

Required Date: 12/19/2014

Start Qty: 5.00

Required Qty: 5.00

MS27039-5-12

Purchased

No

110

Each

51.0000

8

40

MS27039-5-12

Screw

Location

Loc Qty

Loc Code

ST282

51

124604

8

m131049

43

DAS
06
9-09

cmf 15-1-23

Friday, January 23, 2015 1:17:33 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

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LOT TRACKING !!

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt
D3933-1	126996	-5	126980	12/17/2014 11:42:34 AM	\$68.43
D3933-2	126996	-5	126999	12/17/2014 11:42:34 AM	\$80.22
D3935-1	126996	-5	126981	12/17/2014 11:42:34 AM	\$127.39
D3935-2	126996	-5	126992	12/17/2014 11:42:34 AM	\$113.50
D3942-1	126996	-70	127009	12/8/2014 1:28:17 PM	\$2.21
D3942-3	126996	-50	126977	12/5/2014 1:23:24 PM	\$2.13
MS27039-4-10	126996	-20	124552	12/4/2014 7:43:31 AM	\$.24
MS27039-4-14	126996	-30	m130716	12/4/2014 7:43:31 AM	\$.22
MS27039-5-08	126996	-30	m131074	12/9/2014 1:29:19 PM	\$2.45
MS27039-5-12	126996	-31	m130783	12/4/2014 7:43:31 AM	\$1.07
MS27039-5-12	126996	-9	m131049	12/5/2014 12:48:36 PM	\$1.07

DQA: _____ Date: _____



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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other